

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000938**Date Inspected:** 19-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** HP2007259**Summary of Items Observed:**

CalTrans Quality Assurance (QA) Inspector Dan Hernandez was on site at ZPMC Welding Lab to observe the welding of the Procedure Qualification Record (PQR) test plate HP2007259. PQR HP 2007259 is a multiple pass groove weld test coupon welding in the 1G position using the Flux cored arc welding (FCAW) process. Filler metal specification AWS A5.20 and classification E71T-1, electrode diameter 1.4 mm. Test plates were 26 mm thick with a 10 mm back up bar in a butt-Joint fit up. Welding was performed per AWS D1.5 2002, Section 5.13 Production Procedure WPS. Welding was performed by Xing Ji Zhan. QA Inspector observed passes 1-10 during the Day Shift. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Haung Wei and Bureau Veritas Inspector Mr. Arbin Huang were observed monitoring welding activities at the workstation.



---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

### Summary of Conversations:

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

---